

SIP JUN 5

Dart Aerospace Ltd.

Date: Wednesday, 12/20/2006 11:59:01 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	29991			
Estimate Number	10308			
P.O. Number	N/A			
This Issue	12/20/2006	S.O. No. : N/A	Part Number	: D26173
Prsht Rev.	NC		Drawing Number	: D2617 REV D2
First Issue	N/A	Type : MACHINED PARTS	Project Number	: N/A
Previous Run	27738		Drawing Revision	: D2
Written By			Material	: N/A
Checked & Approved By			Due Date	: 12/29/2006
Comment	Est G 04.07.14	Reformat; added step 5 KJ/JLM	Qty:	280
			Um:	40
			Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W
	Comment: Qty.: 0.0765 f(s)/Unit Total : 3.0618 f(s) 6061-T6 Round Bar 1.5" Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) Batch: M19051	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE Turn as per Folio FA437 and Dwg D2617	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:59:02 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 29991

Part Number: D26173

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



*m/ 10/12/06*



*06/12/28*

*260*

Comment: Acid etch and Alodine as per QSI 005 4.1

7.0 QC5

INSPECT WORK TO CURRENT STEP



*280*

Comment: INSPECT WORK TO CURRENT STEP

*M 06/12/28*

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 53

*2807/01/02*

*279*

9.0 QC21

FINAL INSPECTION/W/O RELEASE



*279*

Comment: FINAL INSPECTION/W/O RELEASE

*2807/01/02*

Job Completion



*C 2807/01/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29991
Description: Bushing	Part Number:	D2617-3
Inspection Dwg: D2617	Rev: D2	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

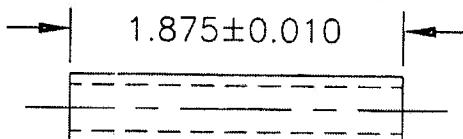
Measured by: <u>J. S</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>66/12/23</u>	Date: <u>66/12/23</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	

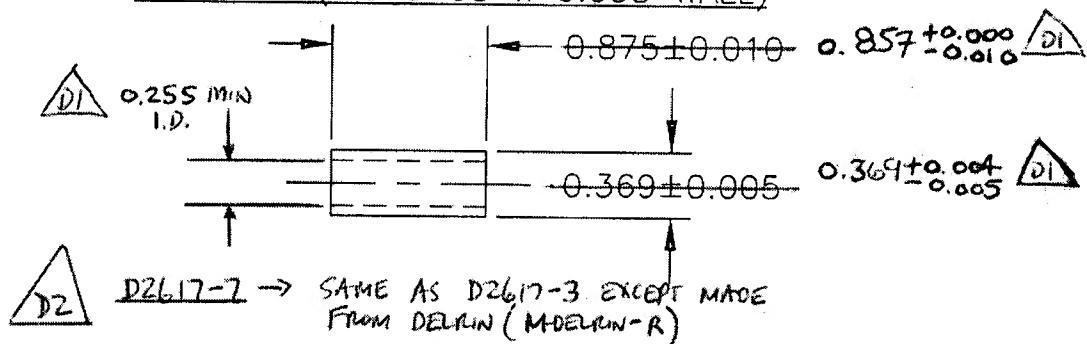


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2617 REV. D SHEET 1 OF 1
DATE	01.07.04		TITLE	SCALE
			BUSHING	1:1
D2   04.04.10 #/12	ADD D2617-7		A   96.10.08	NEW ISSUE
	B   97.05.08			.875 WAS 1.125
	C   97.06.04			0.369 DIA WAS 0.375
	D   01.07.04			ADD MAT'L SPEC AND TOL./DIM. NOTE
	DI   CP-#   04.07.12			CORRECT TOLERANCE (NCR 779)

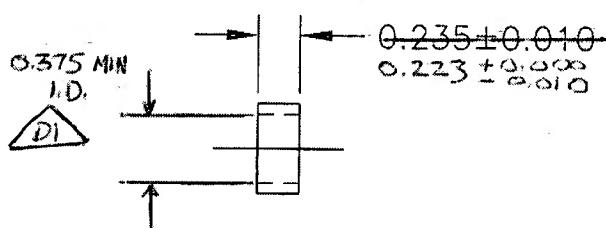
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29991

RELEASED  
01.07.05 #/12

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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